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RBE1120-31502W1
Job Sheet 204042



Part No: RBE1120-31502W1

Job Qty: 1 pcs

Part Name: Press-In & Push-Out Device



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/2/19

Job Tracking No:

Due Date: 12/30/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG RBE1120-31502W1 Rev.B IPP Rev. A 18.10.25 New issue DP Verify DD/IPP Rev. B 19.09.12 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/30/19		0.00	0.10	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		GP 19-01-17
120	QC 5	1 pcs	12/30/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		JAN 17 2020
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/30/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

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					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	12/30/19	0.00 0.00	QC 21 - FG - 21		
				QC 21 - FG - 70		
				QC 21 - SA - 53		

NL 17/01/20

DAS

21

9-09

JAN 17 2020

Part Op 110 - (Small Fab) 1-Assemble as per drawing sheet 1.
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____) -The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE1120-31502W1-15 159	Base Assembly	1 pcs (1 ea)	110-Small Fab - 1	244998.
RBE1120-31502W1-17	Top Assembly	1 pcs (1 ea)	110-Small Fab - 1	248390.
RBE1120-31502W1-7 159	Bushing 2	1 pcs (1 ea)	110-Small Fab - 1	240381
RBE1120-31502W1-9 159.	Pin	1 pcs (1 ea)	110-Small Fab - 1	240376

Job Allocations

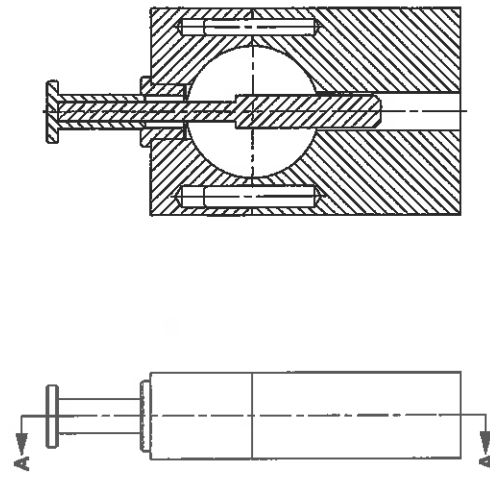
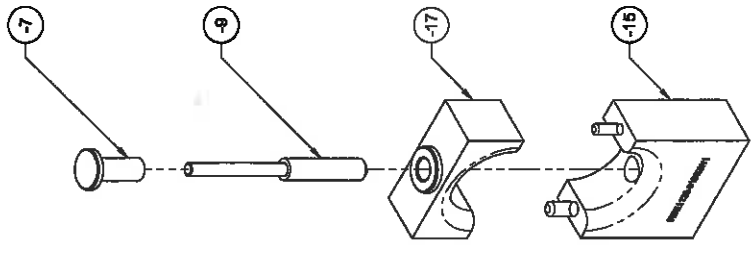
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	RBE1120-31502W1-15	1	0	0
	RBE1120-31502W1-17	1	0	0
	RBE1120-31502W1-7	1	0	0
	RBE1120-31502W1-9	1	0	0

Part Specifications

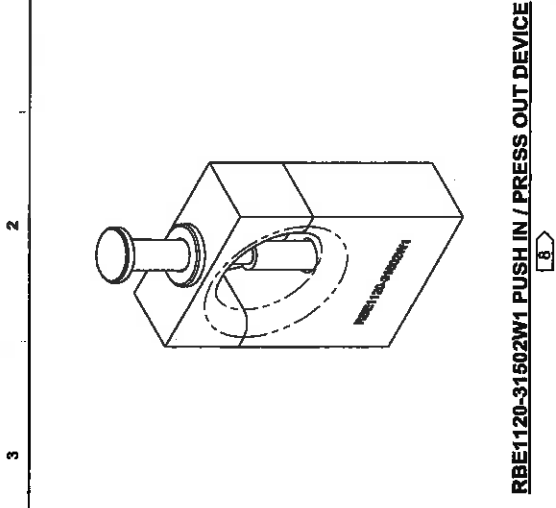
Specifications could not be found.

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ITEM #	QTY	PART #	PART TITLE
-7	1	RBE1120-31502W1-7	BUSHING #2
-9	1	RBE1120-31502W1-9	PIN
-15	1	RBE1120-31502W1-15	BASE ASSEMBLY
-17	1	RBE1120-31502W1-17	TOP ASSEMBLY



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: $XX = \pm 0.1" / \pm 1"$
 $XXX = \pm 0.01" / \pm 0.5"$
 $XXXX = \pm 0.005" / \pm 0.1"$
 $XXXXX = \pm 0.0005" / \pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLY AS SHOWN
 - 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICOANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



RBE1120-31502W1 PUSH IN / PRESS OUT DEVICE

REV.	DESCRIPTION	ECN #	BY
B	SEE PREVIOUS REVISION FOR MORE INFORMATION UPDATED DRAWING TEMPLATE ADDED SUBASSEMBLY ITEMS -15 AND -17 ITEM 18 MS16555-344 WAS ITEM -11 MCMASTER-CARR98361A512 ITEM 19 MS16555-349 WAS ITEM -13 MCMASTER-CARR98361A544 ITEM -15 CONTAINS ITEMS -1, 16, AND 19 ITEM -17 CONTAINS ITEMS -3 AND -5 -1 DIM WAS $\phi 2.488-2.487$ IS $\phi 0.2500-0.2492$ DIM WAS $\phi 1.874-1.868$ IS $\phi 0.1875-0.1867$ DIM WAS 1.800 ± 0.001 IS 1.834 ± 0.001 DIM WAS $\phi 1.345$ IS $\phi 1.510-1.505$ DIM WAS $3X 2.37$ IS 2.365 REMOVED .900, .800, 3X .480, AND 1.160 DIMS -3 DIM WAS 1.800 ± 0.001 IS 1.834 DIM WAS $\phi 1.345$ IS $\phi 1.510-1.505$ DIM WAS $\phi 2.540-2.519$ IS $\phi 0.2556-0.253$ DIM WAS $\phi 6.285-6.255$ IS $\phi 0.6257-0.625$ DIM WAS $\phi 1.907-0.1860$ IS $\phi 0.201-0.196$ REMOVED .800, 3X .480, AND 1.160 DIMS -5 DIM WAS .455 IS $\phi 0.375$ DIM WAS $\phi 8.270-8.267$ IS $\phi 0.6288-0.6262$ DIM WAS $\phi 3.760-0.0054-0.001$ IS $\phi 0.376-0.375$ REMOVED (.270) AND .115 DIMS, ADDED 0.48 DIM AND 48-52 RC HEAT TREAT -7 REMOVED ORIGINATE DIMENSIONS. ADDED R0.008 MAX, 0.98, AND 1.12 DIMS -9 REMOVED 1.65 DIM. ADDED 2.02 DIM	19-870	KPT

DESIGN	KPT	TOOL PART #	RBE1120-31502W1
DRAWN	KPT	TITLE	PRESS IN / PUSH OUT DEVICE
CHECKED	MM	SCALE	1:1
MFG. APPR.	PK	NTS	
APPROVED			
DATE	2019-09-09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. B
SHEET 1 OF 8
SCALE
NTS

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